

Work Order ID 96282

96282

HAI

Page 1

Tuesday, January 22, 2013 11:00:08 AM

Item ID: D4576-10

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Plate, RH

Start Date: 1/22/2013 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/24/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

MUC

Date: 13-1-22

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4576

C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D4576-9 as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

8 0 JM 13-1-30

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

8 0 JM 13-1-30

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(C) 13-02-11 (DAS 09)

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6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

Bend as per dwg
NC BRAKE

0.00

130

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location

0.00

150

Packaging

Memo

0.00

Packaging

SA 13/02/11

AS
15

132 11

8

ST/14

5x

SP
13-2-12

Work Order ID 96282***96282***

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Item ID: D4576-10

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fwd Plate, RH

Stop ***NS2***

Start Date: 1/22/2013 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/24/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

13/2/13

MCS 13-02-12

Picklist Print

Tuesday, January 22, 2013 11:00:08 AM

Page 1

Work Order ID: 96282

Parent Item: D4576-10

Parent Item Name: Fwd Plate, RH

Start Date: 1/22/2013

Required Date: 1/24/2013

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 13.01.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

151.0560

0.046

0.276
0.4

Jm 13-1-30

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

151.056

122245

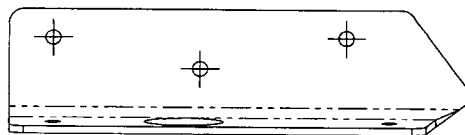
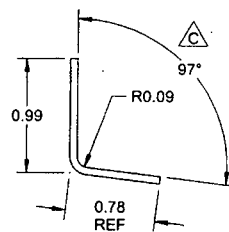
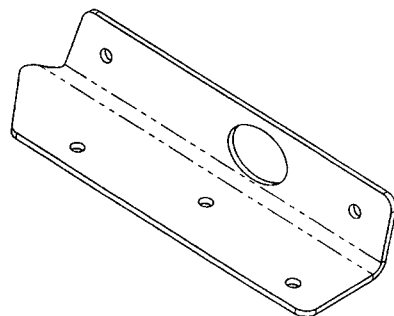
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123136

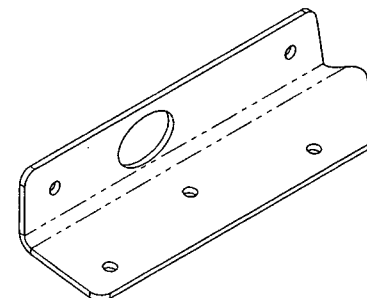
140.9

124428

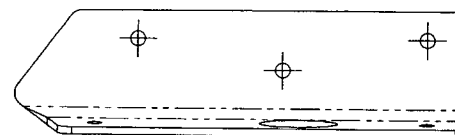
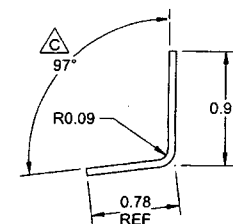
124428



D4576-10 FORWARD PLATE (RH)
(MADE FROM D4576-9F)



96282



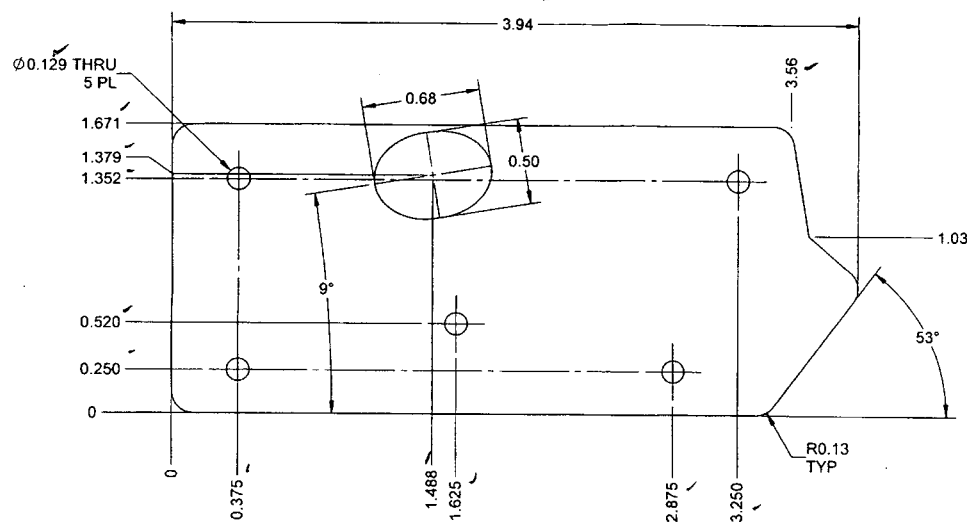
D4576-9 FORWARD PLATE (LH)
(MADE FROM D4576-9F)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.11 lbs

RELEASE
2012-09-26
WMP

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4576	SHEET 11 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HORIZONTAL LINKAGE ASSY	NTS
DATE	12.09.11	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4576-9F FORWARD PLATE
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, ANNEALED, 2B FINISH.
16 GAUGE (0.063 THICK)
PER AMS 5513 OR AMS 5524, OR MIL-S-5059
REF. DART SPEC M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.11 lbs

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RELEASED
2012-09-26
MP